



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-604-041
Job Sheet 198752



Part No: D350-604-041

Job Qty: 1 pcs

Part Name: Rear Locker Extender



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 9/13/19 *10/0/2019*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D350-604-041 REV C, D2273 REV M IPP Rev:Q 03.12.01 Reformat KJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM IPP REV:X 17.01.12 AS PER CHG010 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Purchasing	1 pcs	9/13/19	9/13/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	<i>DP OCT 16 2019</i>
120	Packaging 2-1 - Receive - B4B	1 pcs	9/13/19	9/13/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	<i>DP OCT 16 2019</i>
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S222779



Part: D350-604-041

Job No: 198752

Serial No/Batch: S222779

Revision: C/M

Inspector:

Exp Date:

Instructions: TC STC SH90-4 Issue 4, 5A STC SR00463N

					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130 QC 6	1 pcs	9/13/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
140 Small Fab - 2 - B4B	1 pcs	9/13/19	0.00 0.00		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
150 QC 5	1 pcs	9/13/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
155 Packaging 1-1 - Pick Kit - B4B	1 pcs	9/13/19	0.00 0.00		Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	NC NOV 0 1 2019
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
158	QC 4	1 pcs	9/13/19	0.00 0.00	QC 4 - 28
					QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
					DAS 78 NOV 0 1 2019 9-89
160	Packaging 3-1 - Stock - B4B	1 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
165 DC - 1 - B4B	1 pcs	9/13/19	0.00 0.00	DC - 1 - B4B	DAS NOV 0 1 2019
				DC - 2 - B4B	DAS
170 QC 21 - FG	1 pcs	9/13/19	0.00 0.00	QC 21 - FG - 21	21 NOV 0 1 2019
				QC 21 - FG - 70	21
				QC 21 - FG - 53	

Part Op 110 - Purchasing - Issue P/O: **1624002** Description: D350-604-041 Rear locker extender. Manufacture as per dwg
 Descriptions: D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

120 - Receive & Inspect for Damage & Mat'l Certs - Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached. ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

130 - QC6- All purchased or subcontracted products - Check hole locations to template. DT 8824 Check process sheet and audit.

140 - Small Fab - 1- INSTALL DECALS AS PER DWG (D2728-1)

150 - QC5- Inspect part completeness to step on W/O

155 - Pick Kit ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

158 - QC4- 100% Inspect kits for completeness

160 - Identify as per dwg & Stock Location: _____

165 - Photocopy bluefile and create labels per PPP D350-604-041 CHG0010

170 - QC21- Final Inspection - Work Order Release

x1 plus aug 13. 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-604-041P	Rear Locker Extender	1 Ea (1 ea)	110-Purchasing	5222777
D2268	Placard	1 pcs (1 ea)	140-Small Fab - 2 - B4B	5201795
D2269	Placard	1 pcs (1 ea)	155-Packaging 1-1 - Pick Kit - B4B	5184247
D5062-041	Bracket Assembly	1 pcs (1 ea)	155-Packaging 1-1 - Pick Kit - B4B	5213031

Job Allocations

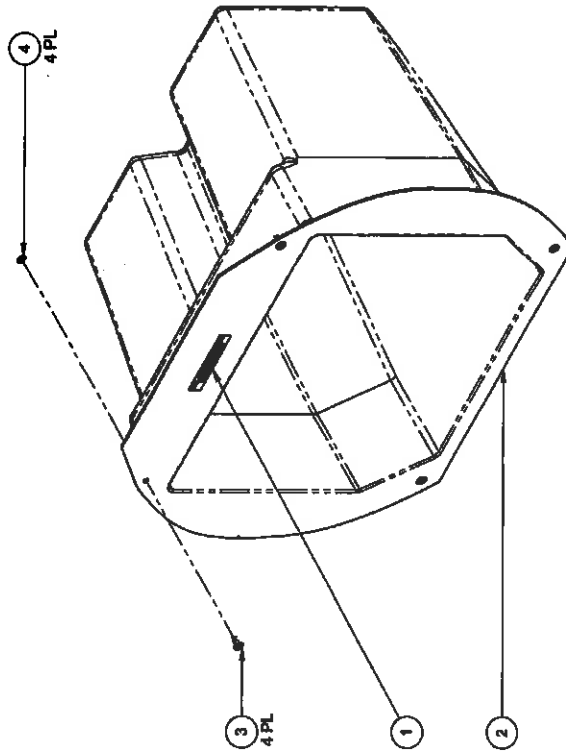
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D350-604-041P	1	0	0
140-Small Fab - 2 - B4B	D2268	1	21	0
155-Packaging 1-1 - Pick Kit - B4B	D2269	1	19	0
	D5062-041	1	2	0

Part Specifications

Specifications could not be found.

Plex 8/6/19 10:07 AM Dart.lajeunesse.marie

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
2	1	D2288	PLACARD
3	1	D2273	REAR LOCKER EXTENDER
4	4	2600-6	CAM LOCK STUD
5	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 5.5 TO 7.5 lbs
 - 8) INSTALL D2288 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 198752MCS
19-0806



RELEASED
2014-07-06

REV.	DESCRIPTION	BY	DATE
C	REMOVE D2273-1 D2273-1 DECALS (2N CS-1) REMOVED NOTES, UPDATED PART WEIGHT INCORPORATED D2273-1 PLACARD AND CURRENT STANDARD (2N CS-1) ADD D2273-1 PLACARD AND ORIENTATION NOTE (2N CS-1)	ML	13.12.18
B	NEW ISSUE	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
DESIGN	DW	ML	
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS		
DATE	14.01.02		

APPROVED

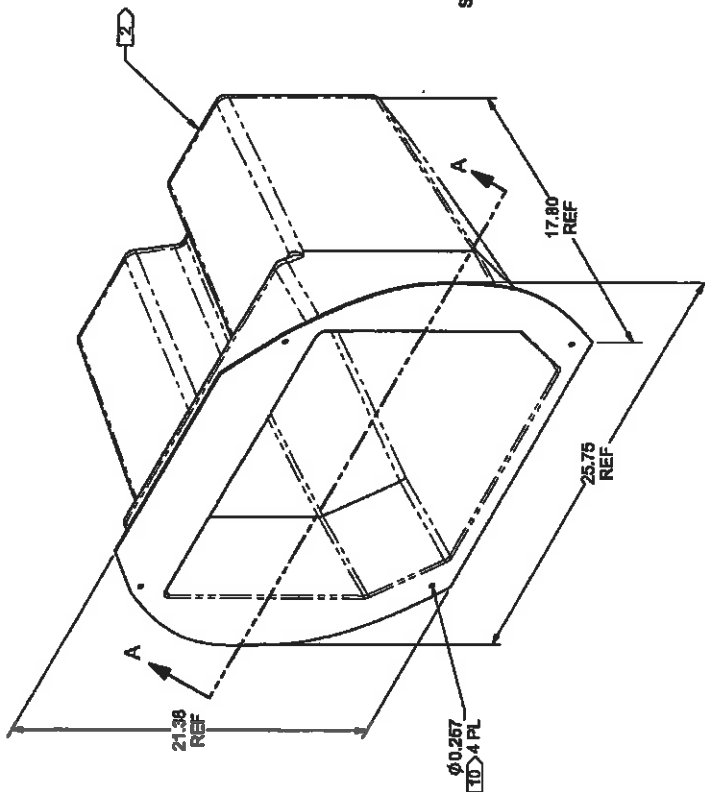
DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
DRAWING NO.	D350-604-041
TITLE	RLE ASSY
SCALE	NTS
REV. C	SHEET 1 OF 1
COPYRIGHT © 2002 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER



D2273 REAR LOCKER EXTENDER

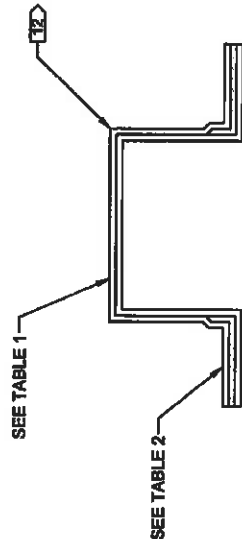
TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 34 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4600-PB-23G (GREEN)

- NOTES:
- 1) MATERIAL: SEE TABLE 3
 - 2) FINISH: SEE TABLES 1, 2, & 3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 5.5-7.5 lb
 - 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
 - 9) LAYUP USING DT871 MOLD. WET LAYUP WITH BAG/VACUUM
 - 10) TRIM & DRILL PER DT806. OPEN HOLES TO Ø0.257
 - 11) CONSTRUCTION: SEE TABLES 1 & 2
 - 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

RELEASED
N 2017-01-11
EJW/7-SM

SECTION A-A



M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT. REMOVE PAINT FINISH OPTION (NOTE 2)	DB	16.06.19
L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MATL PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA PR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2530PANK745	SPM	13.06.19
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.06
F	PRIMER LE 3404-8/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 844W005 GELCOAT TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	06.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	DB		
CHECKED	ML		
ENG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	16.05.19		
DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA			
DRAWING NO. D2273			
REV. M			
SHEET 1 OF 1			
SCALE			
350 REAR LOCKER EXTENDER NTS			
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Other/Details: _____							
				Completed By _____							
Lead hand / Supervisor _____						QC / QA Coordinator _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044252



Supplier: FDC001-VC
FDC Composites Inc.
45 chemin de L'Aéroport, Local 26
St-Jean-sur-Richelie
QC
J3B 7B5 Canada
Phone: 450-357-1344 ext303
Fax: 450-357-1194

PO No: POHB044252
PO Date: 8/13/19
Due Date: 10/7/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198751	D350-604-041P			Rear Locker Extender	Firmed	-	10/7/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
2	198752	D350-604-041P			Rear Locker Extender	Firmed	-	10/8/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
3	198753	D350-604-041P			Rear Locker Extender	Firmed	-	10/9/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
4	198754	D350-604-041P			Rear Locker Extender	Firmed	-	10/10/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00

Grand Total: \$3,340.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/13/19 10:46 AM dart.lussier.patrick

FDC Composites inc.

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Suite 26
Saint-Jean-sur-Richelieu, Québec J3B 7B5
Canada
Tel: (450) 357-1344
Fax: (450) 357-1194

Packing Slip

Packing Slip No.: 10341
Date: 2019-10-11
Page: 1

Sold to:	Ship to:
DAE-CAD Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada	DAE-CAD Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada
Order No.: HB044252	Sold By:
Shipped By:	Ship Date:
Tracking No.:	

Item No.	Unit	Description	Quantity
DAE001	Chaque	Rear Locker Extender, 350 PO Item: HB044252 FDC ID: DAE001-171 2019-10-09 FDC ID: DAE001-168 2019-09-12 FDC ID: DAE001-169 2019-09-13 FDC ID: DAE001-174 2019-10-09	4
Comment:			

RECEIVED
OCT 15 2019
DART AEROSPACE LTD.



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: HB044252

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198751	DAE001-171	2019-10-09
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198752	DAE001-168	2019-09-12
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198753	DAE001-169	2019-09-13
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198754	DAE001-174	2019-10-09

DAS
81
9-89

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:

Marjorie Geoffrion
Marjorie Geoffrion, Quality Inspector

Date: 2019-10-10